

161865

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/31/2017 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/2/2017 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: Process Plan:  Date: MAY 23 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	JUN 01 2017	DAS 6							
DC	Document Control	0.00							
Doc.Control -USB or Paperwork	Memo	0.00							
	Photocopy bluefile & type labels per PPP D412-698-023		CHG003						
110	Pick Kit	0.00							
Packaging									
Packaging	Memo	0.00							
120	QC4- 100% Inspect kits for completeness	0.00							
QC									
Quality Control	Memo	0.06							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 161865

Tuesday, May 23, 2017 10:59:13 AM

161865

Page 2

Item ID: D412-698-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/31/2017 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging					2	DAS 28 9-89		JUN 27 2017
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023 Location: FG022								
140	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		JUN 27 2017
140									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

JUN 27 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, May 23, 2017 10:59:12 AM

Page 1

Work Order ID: 161865

161865

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/31/2017

Required Date: 6/2/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-11

Manufactured No

110

Each

10.0000

1

2

**

CWB

JUN 05 2017

D3552-11

Door Prop

Location

Loc Qty

Loc Code

FG

4

128491

2

151291

1

80345

1

ST363

6

159139

6

D3594-043

Manufactured No

110

Each

2.0000

1

2

**

DAS
6
9-89

JUN 25 2017

D3594-043

Floor Doubler Assembly, LH

Location

Loc Qty

Loc Code

Quarantine

1

147748

1

ST

1

148698

1

D3594-044

Manufactured No

110

Each

5.0000

1

2

**

CWB

JUN 05 2017

D3594-044

Floor Doubler Assembly, RH

Location

Loc Qty

Loc Code

Quarantine

1

147749

1

ST504

4

159708

4

DAS
28
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Tuesday, May 23, 2017 10:59:12 AM

Page 2

Work Order ID: 161865

161865

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/31/2017

Required Date: 6/2/2017

Start Qty: 2.00

Required Qty: 2.00

D3594-5 Manufactured No

110 Each

6.0000

D3594-5

Doubler

** 1 2
CWB

JUN 05 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST041

6

158834

6

D3622-1 Manufactured No

110 Each

37.0000

D3622-1

Ball Stud

** 2 4
CWB

JUN 05 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST043

37

158388

37

MS20426AD4-4 Purchased No

110 Each

2,632.000

MS20426AD4-4

Rivet

** 2 4
CWB

JUN 05 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

1149

125445

1149

ST312

1483

m132536

1483

MS21073L5 Purchased No

110 Each

24.0000

MS21073L5

Anchor Nut

** 1 2
CWB

JUN 05 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST298

24

m135058

1

m137361

23

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No.: _____ NCR No.: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, May 23, 2017 10:59:12 AM

Page 3

Work Order ID: 161865

161865

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/31/2017

Required Date: 6/2/2017

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0516J

Purchased

No

110

Each

229.0000

2

4

NAS1149D0516.J

Washer

**

CWB

JUN 05 2017

9/5/16

Location

Loc Qty

Loc Code

ST264

229

M134943

29

M137166

200

4

DAS
28
89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

REFERENCE ONLY

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: F

Date: 16.05.11

Work Order ID 161865

Tuesday, May 23, 2017 10:59:13 AM

161865

Page 1

Item ID: D412-698-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/31/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date: MAY 23 2017 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	JUN 01 2017							
IIN D412-698	F								
100	Document Control	0.00	DAS						
100	DOCUMENT CONTROL	0.00	B						
DC	Memo	0.00	2						
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-698-023	CHG003	JUN 02 2017						
110	Pick Kit	0.00							
110		0.00							
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120		0.06							
QC	Memo								
Quality Control									



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Eagle Copters Ltd.
823 McTavish Road N.E.
Calgary, Alberta
Canada T2E 7G9

Number: SH92-43

Issue No.: 5

Approval Date: August 26, 1992

Issue Date: September 14, 2007

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

BELL 204B, 205A, 205A-1, 205B, 212, 214B, 214B-1, 412,
412 CF, 412 EP

Canadian Type Certificate or Equivalent:

BELL 205B H-104
BELL 214B, 214B-1 H-80
BELL 212, 412, 412 CF, 412 EP H-86
BELL 204B, 205A, 205A-1 H1SW

Description of Type Design Change:

Serviceability Kit: Aux Cowl latches, cockpit door wear pads,
cabin door handle, sliding door roller system and automatic
door opener kit

**Installation/Operating Data,
Required Equipment and Limitations:**

Configuration 1:

Installation of Serviceability Kit to be done in accordance with DOT approved Aero Design Ltd.,
Document Control List A-85-DCL1, Revision 1, dated 27 January 1997, or later approved Revision.

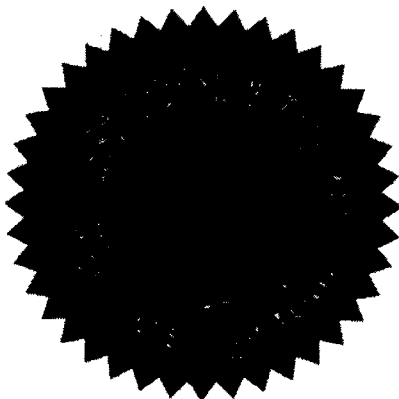
Configuration 2:

Installation of Door Modification Kits to be done in accordance with Transport Canada (TC) approved
Dart Aerospace Ltd. Installation Instructions IIN-D412-698, Revision D or later TC approved revision.

Inspection of Door Modification Kits is to be performed in accordance with Dart Aerospace Ltd.
Instructions for Continued Airworthiness ICA-D412-698, Revision 3 or later TC accepted revision.

-END-

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein.
Prior to incorporating this modification, the installer shall establish that the interrelationship between this
change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the
modified product.




Greg Oucharek
Senior Aircraft Certification Engineer
For Minister of Transport